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D350-591-214
Job Sheet 190181



008146

Part No: D350-591-214

Job Qty: 2 ea

Part Name: Heli-Access-Step™ RH - High Gear, Short Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/5/19

Job Tracking No:

Due Date: 3/8/19

Created By: Jesse White

Type: Stock

Description: SIOP

Note: DWG REV H IPP Rev:B 05.10.14 Modified step 10 KJ/EC IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM IPP Rev:C 06-06-27 Revised as per DSI9340 JLM IPP Rev:D 10.11.15 update qty on AN4-11A DD verf:EC IPP REV:E 14.12.17 ADD DSI9712-011 DD VERF:JLM IPP REV:F 16.03.16 IIN REV.H DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	3/8/19		0.00	0.00	Start Up Stores/Pkg-2		SA
270	Packaging	2 pcs	3/8/19		0.00	0.00	Packaging1-3		DASB 19 7019
280	QC	2 pcs	3/8/19		0.00	0.00	QC4		46
290	Packaging	2 pcs	3/8/19		0.00	0.00	Packaging3-1		DAS 46 MAR 08 2019
295	DC	2 pcs	3/8/19		0.00	0.00	DC		46 MAR 08 2019
300	QC21-FG	2 Ea	3/8/19		0.00	0.00	QC21		9-89

Part Op 290 - Identify and pack for shipping as per PPP D350-591-214 Location:FG039
Descriptions: 295 - Photocopy bluefile and type labels as per PPP D350-591-214 CHG005 ✓

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-35A	Bolt	4 Ea (2 ea)	90-Start up Operation	510329
AN4-15A	Bolt	8 Ea (4 ea)	90-Start up Operation	51344364
AN5-36A	Bolt	4 Ea (2 ea)	90-Start up Operation	5099504
D2230-3	Mounting Lug	4 pcs (2 ea)	90-Start up Operation	5137811X2 5153 203x2
D2618	Bushing	4 pcs (2 ea)	90-Start up Operation	51416466
D2732-030	Rubber Cushion - 3"	8 pcs (4 ea)	90-Start up Operation	5141533
D3235-1	Mounting Lug	4 pcs (2 ea)	90-Start up Operation	5150059
D3338-1	Mounting Lug	2 pcs (1 ea)	90-Start up Operation	5109230
MS21042L3	Nut	4 Ea (2 ea)	90-Start up Operation	5132364
MS21042L4	Nut	12 Ea (6 ea)	90-Start up Operation	5149814
MS21042L5	Nut	4 Ea (2 ea)	90-Start up Operation	5093592
NAS1149D0363J	Washer	8 Ea (4 ea)	90-Start up Operation	5123436
NAS1149D0463J	Washer	24 Ea (12 ea)	90-Start up Operation	5150216
NAS1149D0563J	Washer	8 Ea (4 ea)	90-Start up Operation	5123450
AN4-16A	Bolt	8 Ea (4 ea)	90-Start up Operation	5152617
D3078-042	Step Assembly, Hi Short RH	2 pcs (1 ea)	270-Packaging	5153122

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION		DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐	
	Use-as-is ☐	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier Quality ☐	

Date :	Sequence #:	QTY Affected :	MRB (QSI042)
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Description Work Order Deviation	 Container No: S154722 Part: D350-591-214 Job No: 190181 Serial No/Batch: S154722 Revision: Inspector: Exp Date: Instructions: TC STC SH92-6 Issue 11 Date: 11/19/2011 FAA STC SH967NE	Completed By
		Ind / Supervisor
		QA Coordinator

Root Cause	FAULT CATEGORY			
	☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
☐ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors	Other/Details:			

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-35A	4	151	0
	AN4-15A	8	408	0
	AN4-16A	8	613	0
	AN5-36A	4	104	0
	D2230-3	4	6	0
	D2618	4	322	0
	D2732-030	8	575	0
	D3235-1	4	310	0
	D3338-1	2	66	0
	MS21042L3	4	2,768	0
	MS21042L4	12	3,423	0
	MS21042L5	4	875	0
	NAS1149D0363J	8	856	0
	NAS1149D0463J	24	4,794	0
	NAS1149D0563J	8	991	0
270-Packaging	D3078-042	2	0	0
Part Specifications				
Specifications could not be found.				

Plex 2/5/19 2:06 PM dart.white.jesse

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	<i>Heli-Access-Step™</i> , Short Step – High Skid, LH
	X					D350-591-214	<i>Heli-Access-Step™</i> , Short Step – High Skid, RH
		X				D350-591-215	<i>Heli-Access-Step™</i> , Short Step – Low Skid, LH
			X			D350-591-216	<i>Heli-Access-Step™</i> , Short Step – Low Skid, RH
				X		D350-591-311	<i>Heli-Access-Step™</i> , Long Step – High Skid, LH
					X	D350-591-312	<i>Heli-Access-Step™</i> , Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 REV. 3

REF TCCA STC: SH92-6

REF FAA STC: SH967NE

1.0 Purpose

It has come to DART's attention that it may be difficult to fasten the D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Step Installations to the forward crosstube due to variations between crosstubes. For this reason, DART is adding the D3338-1 Mounting Lug to the D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Step Kits at CHG 004 and later.

For D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Step Kits at CHG 003 and earlier, DSI 9712-011 Mounting Lug Kit can be procured from DART. The kit contains all parts to upgrade a single step kit.

2.0 Installation

- 2.1 It is acceptable to install the D3338-1 Mounting Lug in lieu of the D2230-1 Mounting Lug as required to reduce the gap between step and the forward crosstube in accordance with the figures of this service instruction.
- 2.2 The height to set up the D350-591-133 Maintenance Step has been revised from 7.0in to 6.0in $\pm$ 1.0in to provide more flexibility. See sheet 2 of this service instruction.
- 2.3 In all other respects, install the D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Steps in accordance with Section 3.1 of Installation Instructions D350-591 or Section 32.1 of Instructions for Continued Airworthiness ICA-D350-591.

3.0 Parts List Change

The following additional part is provided with D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Steps at CHG 004:

Qty -133	Qty -213	Qty -214	Part Number	Description
X			D350-591-133	Heli-Access-Step™, Aft Maintenance Step
	X		D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
		X	D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
1	1	1	D3338-1	MOUNTING LUG (ADD)

4.0 DSI 9712-011 Mounting Lug Kit Parts List

For existing D350-591-133 Aft Maintenance Steps and D350-591-213/-214 Heli-Access-Steps at CHG 003 or earlier, one DSI 9712-011 kit upgrades one step installation:

Qty -011	Part Number	Description
X	DSI 9712-011	Mounting Lug Kit
1	D3338-1	MOUNTING LUG

5.0 Weight and Balance

There is a negligible weight change associated with this modification.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: D. SHEPHERD (DE # 02)

DATE: 14.12.04
CERT. NO.: SH92-6
ISSUE NO.: 11

A	NEW ISSUE	MB	14.10.22
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>1</u>	DART AEROSPACE LTD	
DRAWN	<u>1</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>1</u>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9712	SHEET 1 OF 3
APPROVED	<u>1</u>	TITLE	SCALE
DE APPR.	<u>1</u>	INSTALLATION OPTION	NTS
DATE	14.10.22	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	